

# Work Order ID 67125

Wednesday, March 09, 2011 8:41:55 AM



Page 1

Item ID: D3479-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 3/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: [Signature] Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3479	Rev B

100 0.00



SHEAR

Shear Memo 0.00

Shear Cut Flat pattern 2.50" X 8.50" as per Dwg D3479

(3X)

= 7 m-h 11/03/10

110 0.00



Small Fab

Small Fab Memo 0.00

Small Fab 1-Deburr 2-Roll part as per Dwg D3479 3-Spot weld as per Dwg D3479 and Dart QSI 018 4-Fabricate Bead using Rotary Machine as per Dwg D3479 5-Form as per dwg D3479

(3X)

= 7 m-h 11/03/10

120 0.00



QC11- Inspect spot weld per QSI004

QC Memo 0.00

Quality Control

SO 11/03/10 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67125**

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Item ID: D3479-1

Accept



Setup Start



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Stop



Item Name: Tube

Start Date: 3/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

So 11/03/11

(3)

Memo

0.00

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 60

0.00

Memo

0.00

11/3/11 302

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/11 11

mf

11-03-11

# Picklist Print

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Page 1

Work Order ID: 67125

Parent Item: D3479-1

Parent Item Name: Tube




Start Date: 3/9/2011

Required Date: 3/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-02-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			100	sf	47.3100	0.14	0.42			

Location

Loc Qty

Loc Code

MAT20

47.31

109398

16.06

112885

31.25



M-L 11/03/10

0.42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

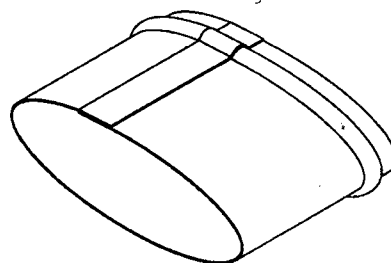
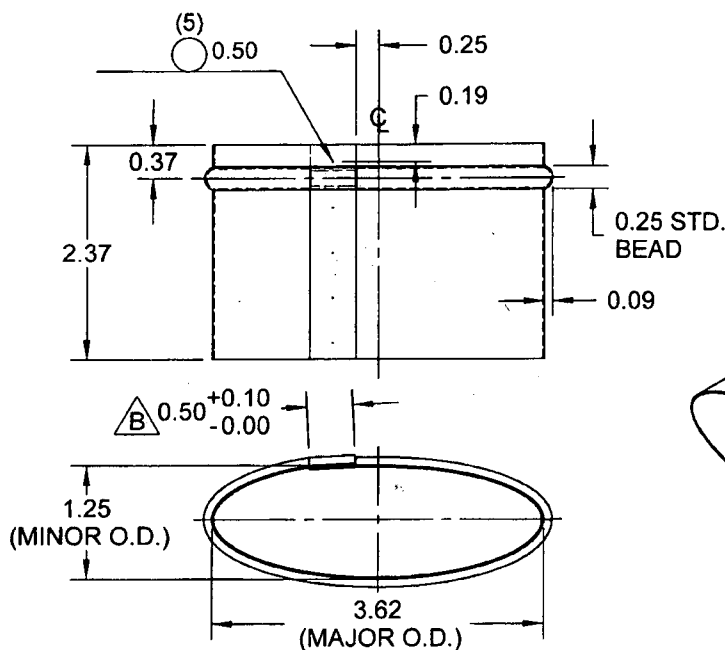
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



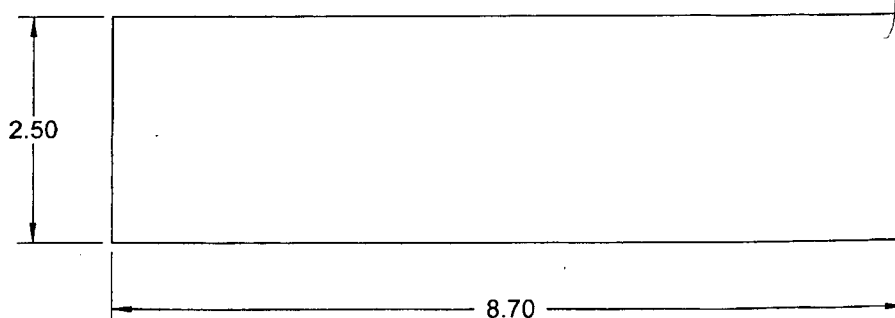
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2

RELEASED  
09/01/20 NP



67125

**D3479-1 TUBE**



**D3479-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\Delta$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 96

EMPLOYEE: Marc Meyers

PART NUMBER: D 3479-1

JOB NUMBER: B 67125

MATERIAL TYPE: 304

MATERIAL THICKNESS: .013

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/6/83

QUALIFIER: SB